

ARCTEC® E308L-0

Conforms to: AWS A5.22-95 E308LT0-3, ASME SFA5.22



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® E308L-0 is a self shielding flux cored wire for joining stainless steel. This filler metal has a nominal composition of 19% chromium and 9% nickel. The low carbon content increases resistance to intergranular corrosion without the addition of stabilizers such as columbium or titanium. Shielding gas is not required.

APPLICATIONS:

ARCTEC® E308L-0 is designed for joining and cladding of types 301, 302, 304, 304L and 308L austenitic stainless steels. May also be used for welding type 321 and 347 where service temperature does not exceed 500°F (260°C)

PROCEDURE:

Clean weld area free from oil, grease, rust and other surface contaminants. Prepare joints as required.

MECHANICAL PROPERTIES:

Tensile Strength 86,000psi(593MPa)	Yield Strength 58,500psi(403MPa)	Elongation 45%-2"
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OPERATING PARAMETERS:

WELDING PROCESS: FCAW POLARITY: DC Reverse SHIELDING GAS IS NOT REQUIRED.

Optimum Operating Parameters				
Diameter	Stickout	Wire Feed Speed	Amps	Volts
3/32" (2.4mm)	1"(25mm)	112"/min. (284cm/min)	250	26
3/32" (2.4mm)	1"(25mm)	136"/min. (345cm/min)	300	28
3/32" (2.4mm)	1"(25mm)	184"/min. (467cm/min)	350	29
3/32" (2.4mm)	1"(25mm)	221"/min. (561cm/min)	400	30

STANDARD SIZE AND PACKAGING:

Size	Packaging
3/32" (2.4mm)	25 Kg Coil

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